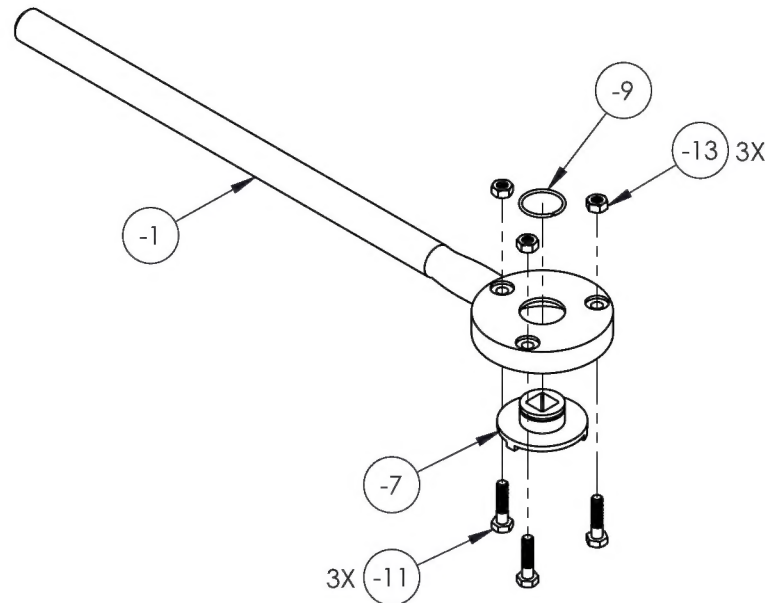


This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	10/24/2016	RJC	JAG



NOTE:
REF. AIRBUS T/N 105-31501W5.



TITLE
ASSEMBLY/DISASSEMBLY FIXTURE

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	DWG NO.	REV
	X		-1	1	HANDLE WELDMENT			2	RBE105-31501W5	1
	1		-3		TUBE	1018/1020 CR		3		
	1		-5		RING	4140/4142		4		
			-7	1	SOCKET	4140/4142		5		
		B/O	-9	1	RND. WIRE SNAP RING	STEEL	Ø15/16 SHAFT X .874 I.D. X .064 C.S. (AR CON RINGS & SPECIALTY #1000-93)	1		
		B/O	-11	3	CAP SCREW	STEEL	M6 X 1 X 25mm CLASS 10.9 (MCMaster-CARR #91310A334)	1		
		B/O	-13	3	HEX NUT	STEEL	M6 X 1 CLASS 10 (MCMaster-CARR #92497A350)	1		
	ASSY -1									

MAT'L
TREAT
FINISH
SPEC

DRAWN BY: CLOUGH
CHECKED: DUERFELDT
OPPS APPR: ANDERSON
QA APPR: LINDSAY
APPROVED: GILBERT

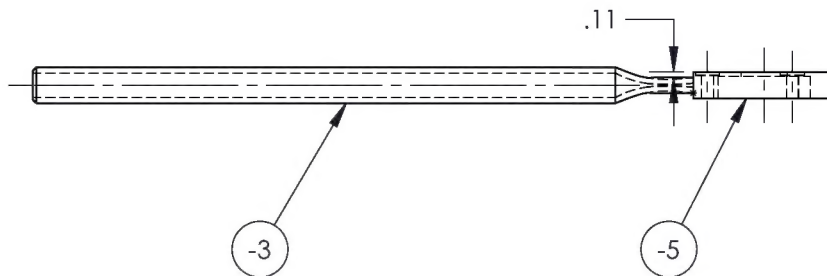
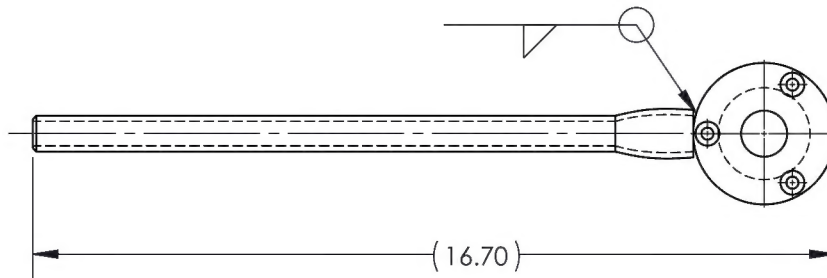
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± .5°
.X ± .1 SURFACES = 125°
1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

USED ON MODEL
EC145

SCALE 1:4
DATE 8/17/2016
SHEET 1 OF 5

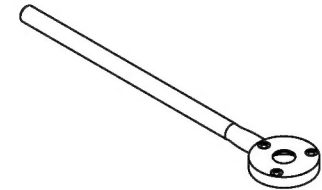
This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL



(1)

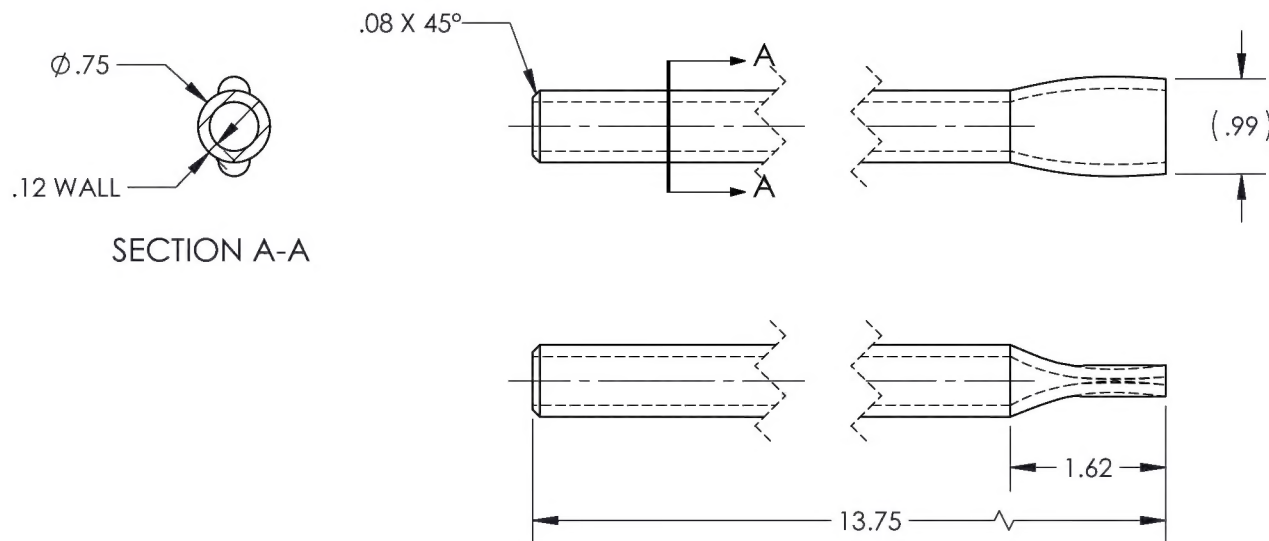
HANDLE WELDMENT



DART AEROSPACE	
TITLE ASSEMBLY/DISASSEMBLY FIXTURE	
DWG NO. RBE105-31501W5-1	REV 1
MAT'L ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125
HEAT TREAT ZINC PLATE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
FINISH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SPEC	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: DUERFELDT	EC145
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:4	DATE 8/17/2016
SHEET 2 OF 5	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL

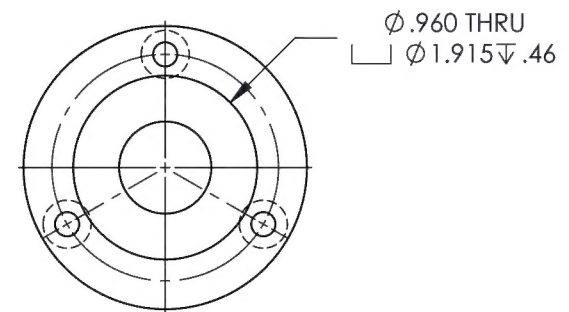
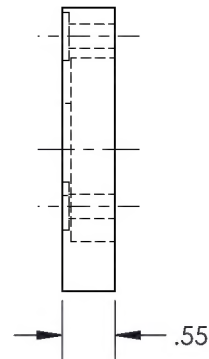
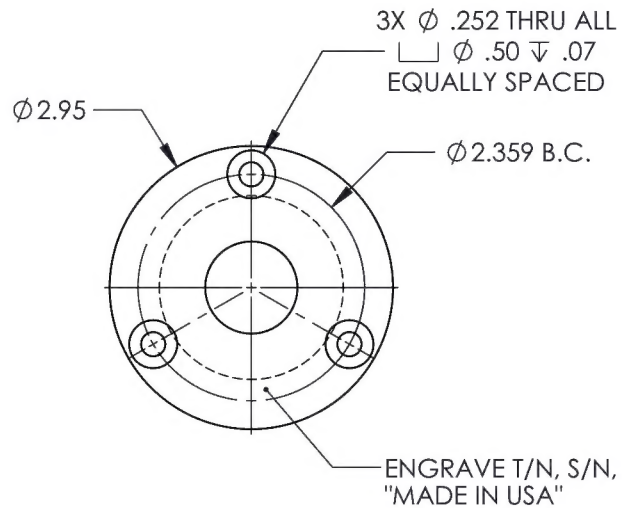


(-3)
TUBE

DART AEROSPACE	
TITLE ASSEMBLY/DISASSEMBLY FIXTURE	
DWG NO. RBE105-31501W5-3	REV 1
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	EC 145
SCALE 1:2	DATE 8/17/2016
	SHEET 3 OF 5

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL

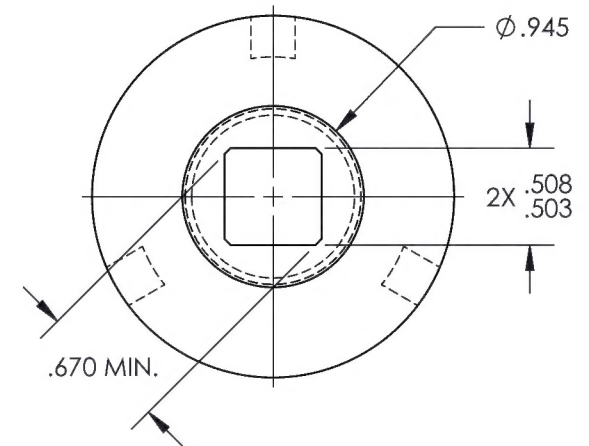
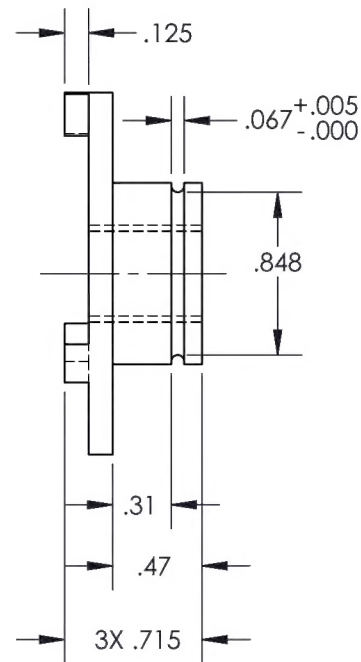
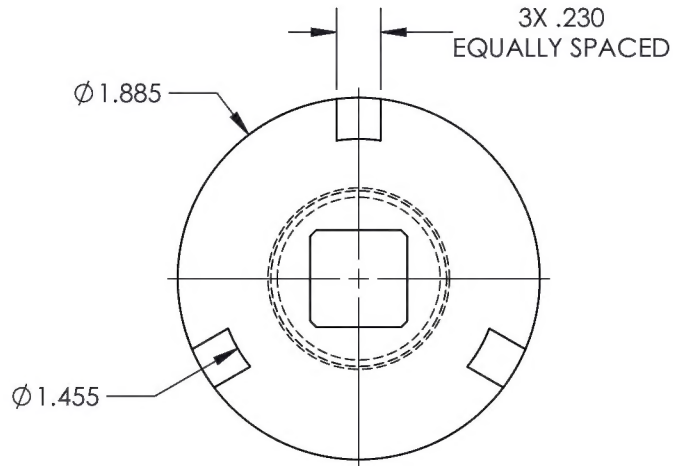
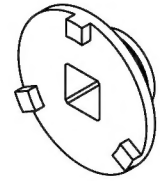


(-5)
RING

DART AEROSPACE	
TITLE ASSEMBLY/DISASSEMBLY FIXTURE	
DWG NO. RBE105-31501W5-5	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	EC145
SCALE 1:2	DATE 8/17/2016
	SHEET 4 OF 5

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



NOTE:
TIMING NOT CRITICAL.

(-7)
SOCKET

DART AEROSPACE	
TITLE ASSEMBLY/DISASSEMBLY FIXTURE	
DWG NO. RBE105-31501W5-7	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 40-45	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125°
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 8/17/2016	USED ON MODEL
SHEET 5 OF 5	EC145